

Claims

1. Rotary offset printing press with at least one print unit (02) for the printing of a web (03; 03') with six printing pages axially alongside each other and a folder machine (12), characterised by one transport cylinder (123) of the folder machines (12) having a circumference for taking up at least seven section lengths of the product in succession around the circumference.
2. Rotary offset printing press as for claim 1, characterised by the transport cylinder (123) having four cutter knives (128; 128') in succession around the circumference of the transport cylinder (123).
3. Rotary offset printing press as for claim 1, characterised by the transport cylinder (123) having two cutter cylinders (127), each with two cutter knives (128), in succession around the circumference of the transport cylinder (123).
4. Rotary offset printing press as for claim 1, characterised by the transport cylinder (123) having one cutter cylinder (127') with four cutter knives (128) in succession around the circumference.
5. Rotary offset printing press as for claim 1, characterised by the retainers (129) on the

transport cylinder (123) being aligned with seven perforation bars (129) successively around the circumference.

6. Rotary offset printing press as for claim 1, characterised by each section length corresponding to the length of a newspaper page.
7. Rotary offset printing press as for claim 1, characterised the transport cylinder (123) receiving three ribbons (109; 111; 112; 113; 114; 116) at the same time from three former folders (101; 102; 103; 106; 107; 108) alongside each other.
8. Rotary offset printing press as for claim 1, characterised the transport cylinder (123) being able to be fed with a total of up to seventy-two layers of ribbons (109; 111; 112; 113; 114; 116) one on top of another.
9. Rotary offset printing press as for claim 1, characterised the transport cylinder (123) having seven retainers (129) successively around the circumference.
10. Rotary offset printing press as for claim 1, characterised by the folder machine (12) having in the intake area two independently driven pairs of draw rollers (124).
11. Rotary offset printing press as for claim 1, characterised by the folder machine (12)

having two cutter cylinders (127) in conjunction with the transport cylinder (123).

12. Rotary offset printing press as for claim 1, characterised by the folder machine (12)

having at least one rotary drive motor (136) mechanically independent of the print unit (03).

13. Rotary offset printing press as for claim 1, characterised by the transport cylinder (123)

having at least one cutter cylinder (127) and one flap fold cylinder (132) of the folder machine (12) driven by a common rotary drive motor (136) mechanically independent of the print unit (03).

14. Rotary offset printing press as for claim 12 or 13, characterised by a creel (133) with

rotary drive by a drive connection from the cylinders (123; 127; 132) of the folder machine (12).

15. Rotary offset printing press as for claim 12 or 13, characterised a discharge device (134)

drive by its own drive motor mechanically independent of the cylinders (123; 127; 132) of the folder machine (12).

16. Rotary offset printing press as for claim 12 or 13, characterised by the drive being

applied to a cutter cylinder (127).

17. Rotary offset printing press as for claim 12 or 13, characterised by the drive being applied to a transport cylinder (123).
18. Rotary offset printing press as for claim 13, 14, 15, 16 or 17, characterised by the drive from the drive motor (136) to one or more of the cylinders (123; 127; 132) being by means of a gearbox.
19. Rotary offset printing press as for claim 1, characterised by a structure (04), in which the web (03; 03') is longitudinally cut into three part webs (03a; 03b; 03c), and a folder structure (11), in which at least one roller (117; 118) is provided for conveying the part webs (03a; 03b; 03c), and by the print unit (02), to at least one roller (117; 118) for conveying the part webs (03a; 03b; 03c) of the folder structure (11) and the downstream folder machine (12) are each driven by rotary drive motors (61; 119; 120; 136) mechanically independent of each other.
20. Rotary offset printing press as for claim 1, characterised by a folder structure (11) having two groups vertically offset from each other each with at least two former folders (101; 102; 103; 106; 107; 108) and at least one folder structure (11) provided with an upstream group of start-up rollers (88; 89; 93).

21. Rotary offset printing press as for claim 20, characterised by both the two webs (03; 03') generating part webs (03a; 03b; 03c; 03c1; 03c2) over to the group of start-up rollers (88; 89; 93) and former folders (101; 102; 103) the one group of former folders (101; 102; 103) and also former folders (106; 107; 108) the other group of former folder (106; 107; 108).
22. Rotary offset printing press as for claim 20, characterised by at least two printing towers (01) each provided with at least two print units (02).
23. Rotary offset printing press as for claim 1, characterised the print unit having at least two pairs each of two cylinders (16; 17), namely one transfer cylinder (17) and one associated form cylinder (16), the transfer and form cylinders (17; 16) each having a width for printing six newspaper pages axially alongside each other, the usable balls of the transfer cylinders (17) having a ratio of 5.8 to 8.8 between their length and diameter.
24. Rotary offset printing press as for claim 1, 19 or 23, characterised the print unit having at least two pairs each of two cylinders (16; 17), namely one transfer cylinder (17) and one associated form cylinder (16), the transfer cylinder (17) having a proof run position with a satellite cylinder (18) in conjunction with which it forms a printing position.
25. Rotary offset printing press as for claim 1, 19 or 23, characterised the print unit having at

least two pairs each of two cylinders (16; 17), namely one transfer cylinder (17) and one associated form cylinder (16), the transfer cylinder (17) having a proof run position of pairs in conjunction forming a printing position.

26. Rotary offset printing press as for claim 23, 24 or 25, characterised by both pairs (16; 17) being driven by at least one drive motor (61) mechanically independently of each other.

27. Rotary offset printing press as for claim 1, characterised by a transfer cylinder (17) and a form cylinder (16) of a print unit (02) of the rotary offset printing press having a circumference which corresponds to at least two printing pages, in particular newspaper pages in broadsheet format, in succession around the circumference.

28. Rotary offset printing press as for claim 1 or 2, characterised by a transfer cylinder (17) of the print unit (02) having three sections (AB; CD; EF) on its outer circumference with three blankets (21) alongside each other in an axial direction.

29. Rotary offset printing press as for claim 1, characterised by a form cylinder (16) of the print unit (02) having six sections (A; B; C; D; E; F) on its outer circumference with at least three, in particular six blankets (19) alongside each other in an axial direction, each with two blankets (19) around the circumference.

30. Rotary offset printing press as for claim 1, characterised by the print unit being arranged as a nine-cylinder satellite print unit (02).
31. Rotary offset printing press as for claim 1, characterised by the print unit being arranged as an H-print unit each with four pairs (16, 17) of cylinders (16; 17) comprising one transfer and one form cylinder (16; 17).
32. Rotary offset printing press as for claim 30, characterised one transfer cylinder (17) and one form cylinder (16) of the print unit (02) being driven by a single mechanically coupled drive, mechanically independent of the m associated printing cylinder (18).
33. Rotary offset printing press as for claim 32, characterised by the paired form cylinder (16) and transfer cylinder being driven by their own drive motor (61) and the printing cylinder (17; 18) having its own drive motor (61).
34. Rotary offset printing press as for claim 31, characterised by a H-print unit in which all four pairs (16, 17) each have their own drive motor (61).
35. Rotary offset printing press as for claim 30, characterised by a nine-cylinder print unit with all four pairs of cylinders (16; 17) each having its own drive motor (61) and the satellite cylinder (18) having its own drive motor (61).

36. Rotary offset printing press as for claim 1, 30 or 31, characterised by all cylinders (16; 17; 18) of the print unit (02) having drive motor (61) mechanically independent of other cylinders (16; 17; 18).

37. Rotary offset printing press as for claims 32 to 36, characterised by the drive from drive motor (61) being transmitted through a gearbox (62), in particular a geared drive gearbox.

38. Rotary offset printing press as for claim 1 or 20, characterised by the folder machine (12) having a group of three upstream former folders (101; 102; 103 or 106; 107; 108) arranged alongside each other.

39. Rotary offset printing press as for claim 38, characterised by three upper each in line with three lower former folders (101; 102; 103; 106; 107; 108).

40. Rotary offset printing press as for claims 20 and 39, characterised by webs running into the group of start-up rollers (89; 93), these being part webs (03a; 03b; 03c) of at least two ribbons (106; 107; 108; 113; 114; 116) arranged above one another, with a variable number of part webs (3a; 3b; 3c) grouped together, of which one is fed an upper and the other is fed to a lower former folder (101; 102; 103; 106; 107; 108).

41. Rotary offset printing press as for claim 1, characterised by the usable bolt of a transfer cylinder (17) of a print unit having a length 1,850 to 2,400 mm.
42. Rotary offset printing press as for claim 1, characterised by the usable bolt of a transfer cylinder (17) of a print unit having a circumference of 850 to 1,300 mm.
43. Rotary offset printing press as for claim 1, characterised by the transport cylinder (123) have an associated cutter cylinder (127'), which has four knives (128) in succession around the circumference.
44. Rotary offset printing press as for claim 3 or 43, characterised by the four knives (128) of the cutter cylinder (127') with four cutter knives (128) varying from the equidistant arrangement of a spacing at $90^\circ - \delta$ and $90^\circ + \delta$ to each other, whereby δ represents an angle less than 2° .
45. Rotary offset printing press as for claim 1, characterised by the provision of a pressure cylinder (143), which in an area of the product pick-up where perforation by perforation pins (144) is performed acts as a backing pad for the transport cylinder (123) in conjunction.

46. Rotary offset printing press as for claim 45, characterised by the pressure element acting in conjunction with the perforation pins having recesses in the surface for accommodating the perforation pins (144).

47. Rotary offset printing press as for claim 3, 4, 10, or 43, characterised by the cutter cylinder (127; 127') for the cut acting in conjunction with the transport cylinder as a backing pad.